

Work Order ID 50908

July 24, 2009 4:08:21 PM



Page 1

Item ID: D3947-4
Revision ID: A
Item Name: Panel, Lower RH Post

Accept



Setup Start



Stop



Start Date: 07/24/2009 Start Qty: 4.00

Required Date: 07/31/2009 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

mc 09-07-24

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

0.00

HandThermo

Memo

Hand Finishing Thermoforming

Cut Blanks to fit frame size

110

0.00



THERMOFORMING MACHINE

0.00

Thermoform

Memo

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-4 and Folio FTA 047 using tool DT9484.

Dwg. Rev. A.

Folio Rev. A.

111973 BB 09/07/29 X4

BB 09/07/29 X2 SCRAP PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/29	110	INCOMPLETE FORMING OF PART Qty 12	AB QLEN	ADJUST HEAT SETTINGS IN FOLD PROGRAM	BB 09/07/29	AB 09.07.31	AB QLEN	AB 09.07.31

* NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	HAND FINISHING THERMOFORMING	0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions as per dwg D3946-1								

BB 09/07/30 X4

IL 09/07/30 X4

BB 09/07/31 X4

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Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

BB 09/07/31 (XY)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 09/07/31 (XY) X

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

PPP
50903

09/17/31 (4x)

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/31 *[Signature]*

mk 09-07-31

Dart Aerospace Ltd

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• **NOTE:** Date & initial all entries

Picklist Print

July 24, 2009 4:08:20 PM

Work Order ID: 50908

Parent Item: D3947-4RevA

Parent Item Name: Panel, Lower RH Post

Comments:

Start Date: 07/24/2009

Required Date: 07/31/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,992.616	14.5011			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1992.6166	
107574	16.62	
111973	797.33	
112176	1178.6666	

M 111973
BB 09/07/31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 50908
Description: PANEL LOWER RH POS		Part Number: D3947-4
Inspection Dwg: 3947	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/07/30

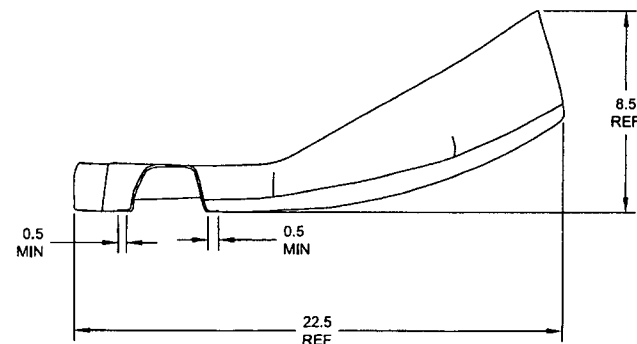
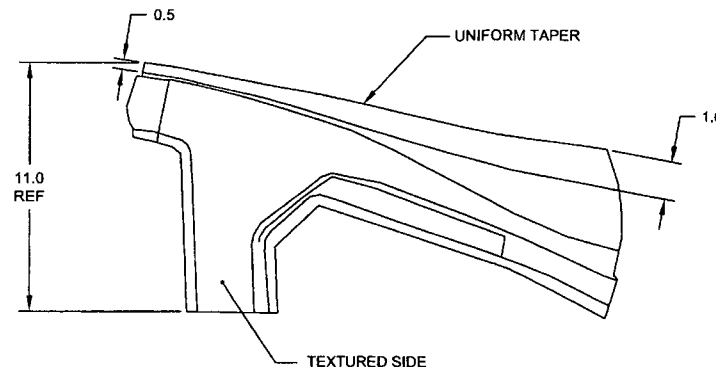
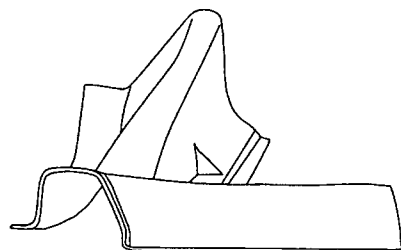
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	1.555	✓			
1.6		1.75	✓			
11.0		11.75	✓			
0.050	Min	0.082	✓			
0.065	Min	0.086	✓			

Measured by: BB Date: 09/07/30
 Audited by: 7 Date: 09-07-30
 Prototype Approval: 7 Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

50908



D3947-4 PANEL, RH

RELEASED
9/18/14 MP

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3947	SHEET 4 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL (AS 350/355)	NTS
DATE	09.05.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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